

Thursday, 12/20/2007 3:21:45 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 WEARPLATE	Split 1
Job Number : 36487		
Estimate Number : 12651	Part Number : D35651	PER REV. C PRELIM. ISSUE 07-02-21
P.O. Number :	Drawing Number : D3565 UNDER REVIEW	
This Issue : 12/20/2007 S.O. No. :	Project Number : N/A	
Prsht Rev. : NC	Drawing Revision : 01R	
First Issue : / / Type : SMALL /MED FAB	Material :	
Previous Run : 36445	Due Date : 1/20/2008	Qty: 40 Um: Each
Written By :		
Checked & Approved By : <u>07.12.21</u>		
Comment : Est Rev : A New Issue 07-01-16 JLM		
est rev B revB dwg 07.04.18 ec		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



5.9556



Comment: Qty.: 0.1418 sf(s)/Unit Total : 5.6700 sf(s)

304/316 .060 Sheet

Batch: 106653 IB 08-1-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: C IB 08-1-2

Prog Rev: C

(42)

2-Deburr if necessary IB 08-1-2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 08-1-2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



counter

Comment: SECOND CHECK

5 08/01/02

(42)

5.0 D30093 CUP



Comment: Qty.: 3.0000 Each(s)/Unit Total : 120.0000 Each(s)

CUP

Batch: 36594

Fe 08/02/21 (2)

B36431

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-02-06	5	task 1 for HAI	W	08-02-06	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Drawing Name: R44 WEARPLATE

Part Number: D35651



Description :

LARGE FABRICATION RESOURCE 1

A/R 2059B Hard Coat rod

Batch:

009

VISUAL WELDING INSPECTION

POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

POSITIVE RECALL

EFFECTIVE 07.12.21 AUTH

RELEASED *08 02 21* DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

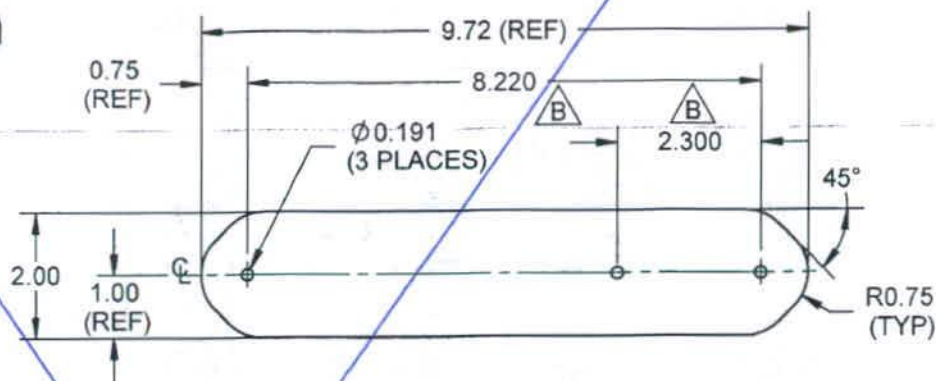
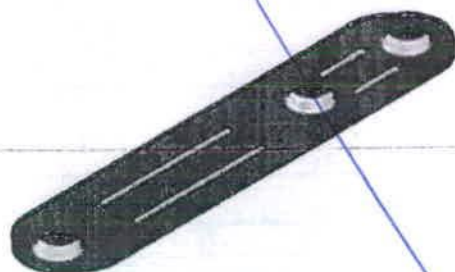
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

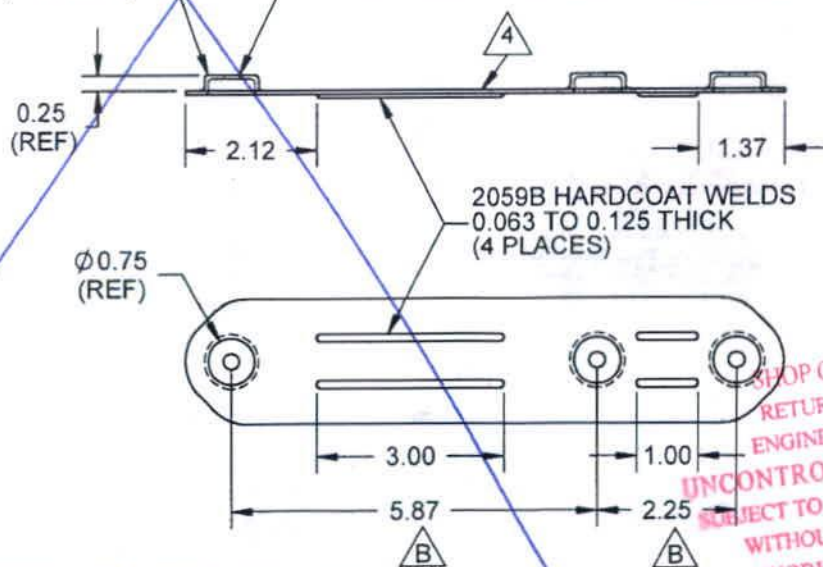
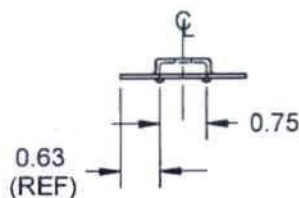
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3565	REV. B SHEET 1 OF 1
DATE 07.03.12	TITLE R44 WEARPLATE		SCALE 1:3
REV	DATE	DESCRIPTION	
A	07.01.09	NEW ISSUE	
B	07.03.12	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	

**D3565-1F FLAT PATTERN**

PUNCH $\phi 0.191$ HOLES WITH
 $\phi 0.75 \times 0.25$ DEEP PUNCH TOOL
(3 PLACES)

OPEN HOLES TO $\phi 0.257$ AFTER
PUNCHING OPERATION (IF NECESSARY)

**RELEASED**

07.03.12

UNDER REVIEW

07.12.12

RE-DESIGN

D3565-1 R44 WEARPLATE

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

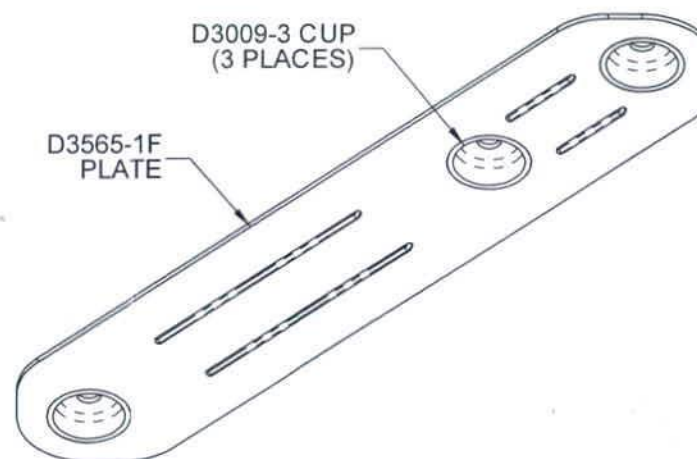
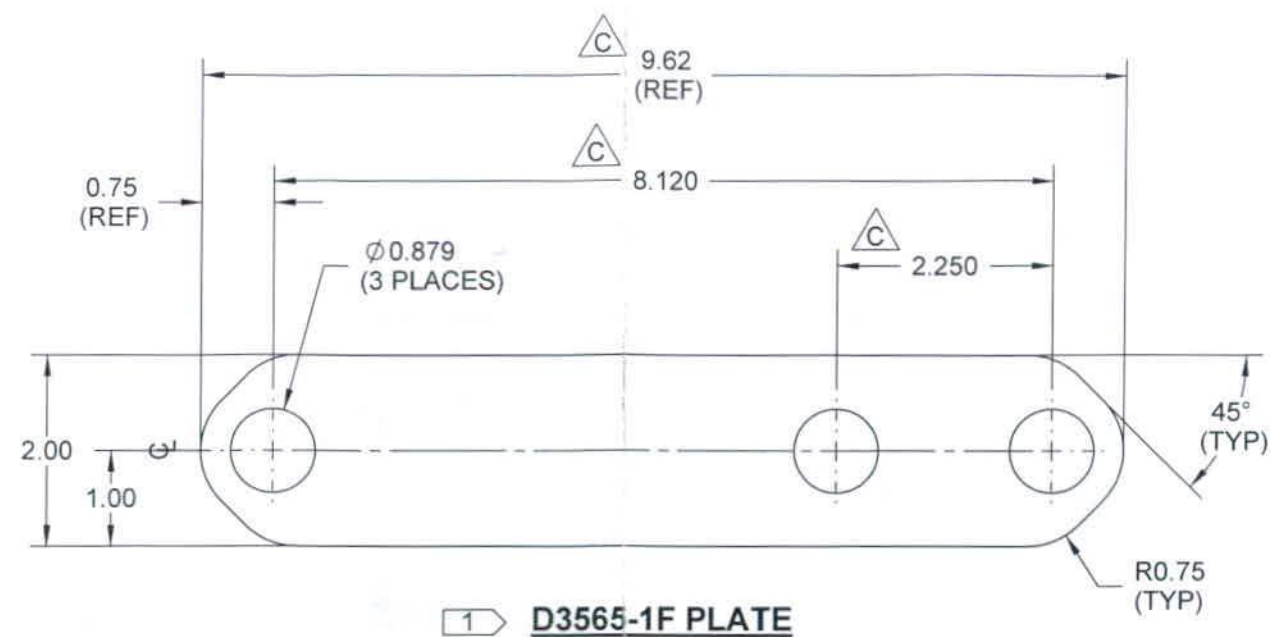
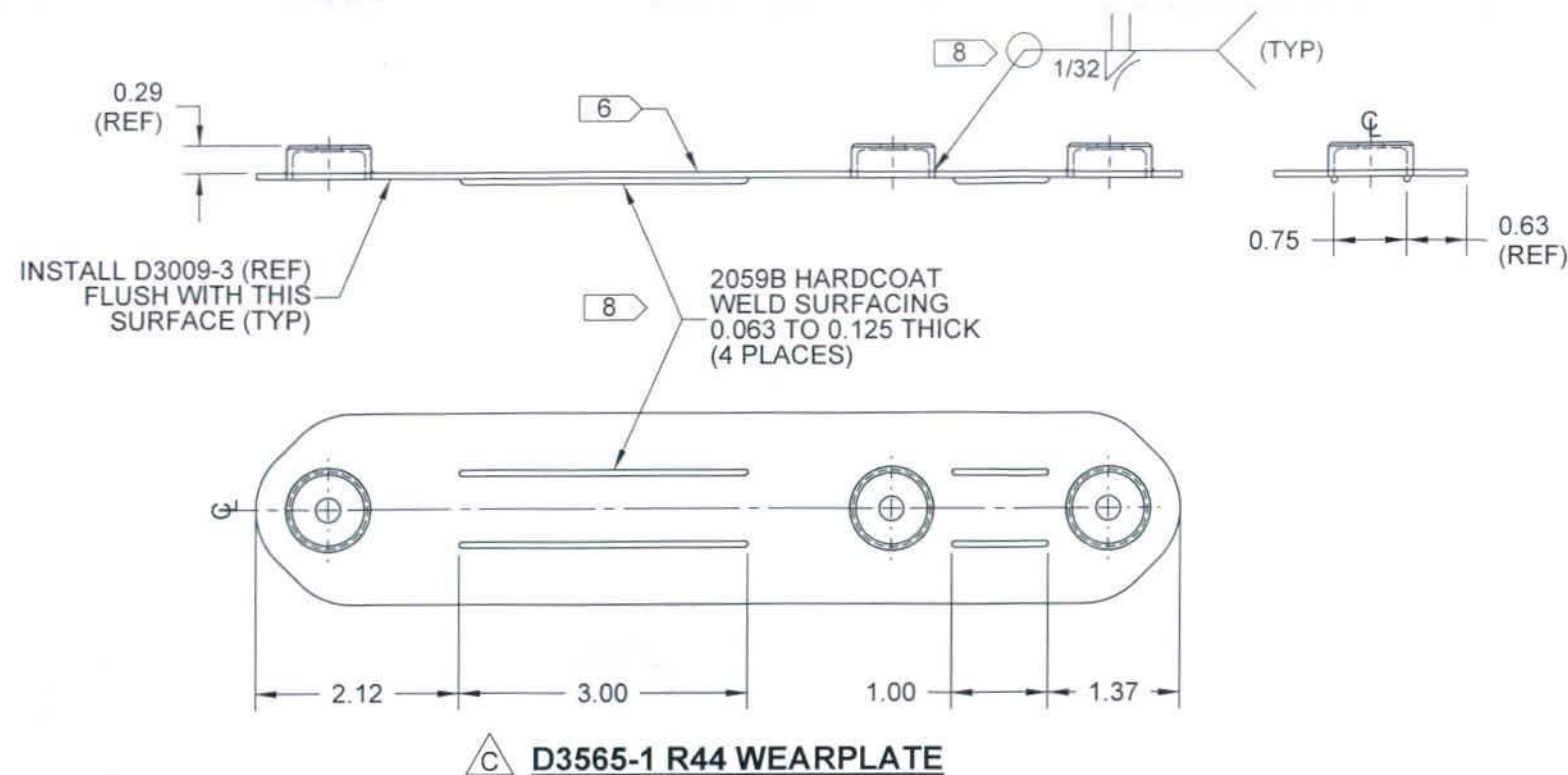
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT ϕ

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1000

1000



D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	R44 WEARPLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT ϕ

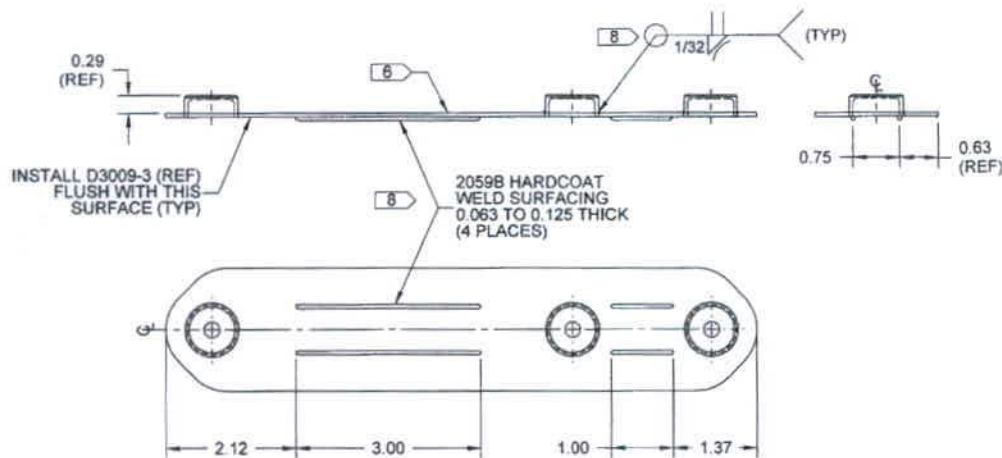
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36487

PRELIMINARY ISSUE

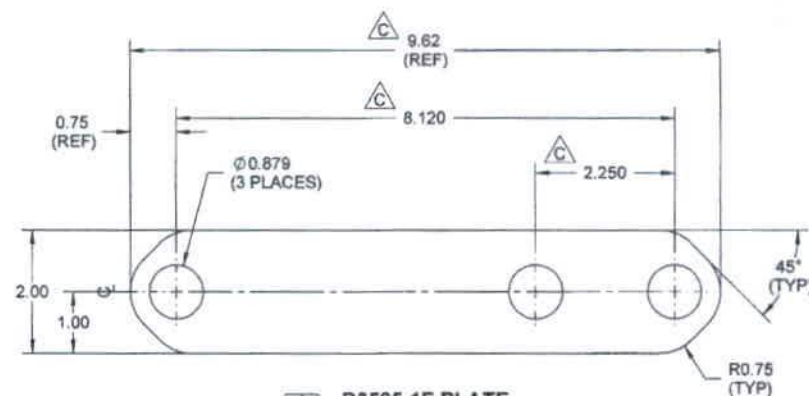
07.12.21

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3565	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		R44 WEARPLATE	1:2
DATE	07.12.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

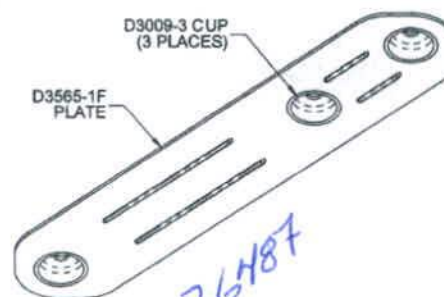
ВЕТНИМВРЯ 1220Е



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT C

RELEASED
06-01-11/10

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3565** REV. C
SHEET 1 OF 1
TITLE **R44 WEARPLATE** SCALE 1:2

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